

Date: Tuesday, 10/06/2008 12:54:25 PM  
 User: Julie Lecocq

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : HINGE BRACKET  
 Job Number : 39787  
 Estimate Number : 10348  
 P.O. Number :  
 This Issue : 10/06/2008 S.O. No. :  
 Prsht Rev. : NC Part Number : D28581  
 First Issue : 11/09/08 Type : MACHINED PARTS Drawing Number : D2858 REV B  
 Previous Run : 36925 Project Number : N/A  
 Material :  
 Due Date : 30/06/2008 Qty: 24 Um: Each  
 Written By :  
 Checked & Approved By : JULIE LECOCQ 08.10.10  
 Comment : Est C 00.06.22 Removed P/O for powder coat EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B1500X01250 6061-T6 Bar 1.5" x 1.25"



Comment: Qty: 0.1767 f(s)/Unit Total: 4.2412 f(s)  
 Material: 1.50" X 1.25"  
 6061-T6 (QQ-A-225/8 or QQ-A-250/11 or QQ-A-200/8)  
 (M6061T6B15001250)  
 Batch 107461

N.A

08/07/02

2.0 BAND SAW BAND SAW



Comment: BAND SAW  
 Cut blanks 6.02"  
 Note: 1 Blank Makes 3 Parts

N.A.

08/07/02

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1  
 1-Machine per folio D2858-  
 2-Deburr as per Dwg D2858000

N.A./ML

08/07/02

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 10/06/2008 12:54:25 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE BRACKET

Job Number: 39787

Part Number: D28581

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*N.A/mk 08/07/02*

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

*SL 08/07/03*

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.3

*FL 08/07/04*

*(24)*

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) per Dart QSI 005 4.3

START TIME:

*7:40*

OVEN TEMPERATURE:

*320*

FINISH TIME:

*8:10*

*FL 08/07/07*

*(24)*

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

*BK 08-07-07*

*(24)*

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

*5751*

*FL 08/07/07*

*(24)*

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*08/07/08*

Job Completion



*W 08.07.08*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 39787
<b>Description:</b> Hinge Bracket		<b>Part Number:</b> D2858-1
<b>Inspection Dwg:</b> D2858	<b>Rev:</b> B	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.171	+0.005/-0.001	Ø0.174	✓			
Ø0.400	+0.006/-0.001	Ø0.399	✓			
R0.125	+/-0.010	R0.125	✓			
0.328	+/-0.010	0.330	✓			
0.820	+/-0.005	0.819	✓			
1.476	+/-0.010	1.479	✓			
0.342	+/-0.010	0.345	✓			
0.875	+/-0.005	0.875	✓			
1.56	+/-0.030	1.570	✓			
0.147	+/-0.010	0.143	✓			
0.717	+/-0.010	0.716	✓			
0.697	+/-0.010	0.695	✓			
0.229	+/-0.010	0.229	✓			
R0.125	+/-0.010	R0.125	✓			
R0.063	+/-0.010	R0.063	✓			
0.063	+/-0.010	0.064	✓			
0.126	+/-0.010	0.125	✓			
0.630	+/-0.010	0.630	✓			
R0.354	+/-0.010	R0.354	✓			
0.965	+/-0.010	0.968	✓			
Ø0.166	+0.005/-0.001	Ø0.167	✓			
R0.125	+/-0.010	R0.125	✓			
32.7°	+/-0.5°	32.7°	✓			

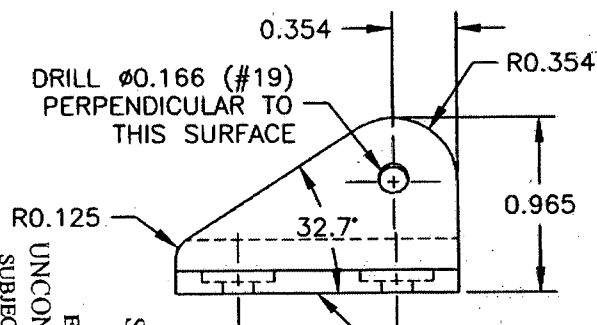
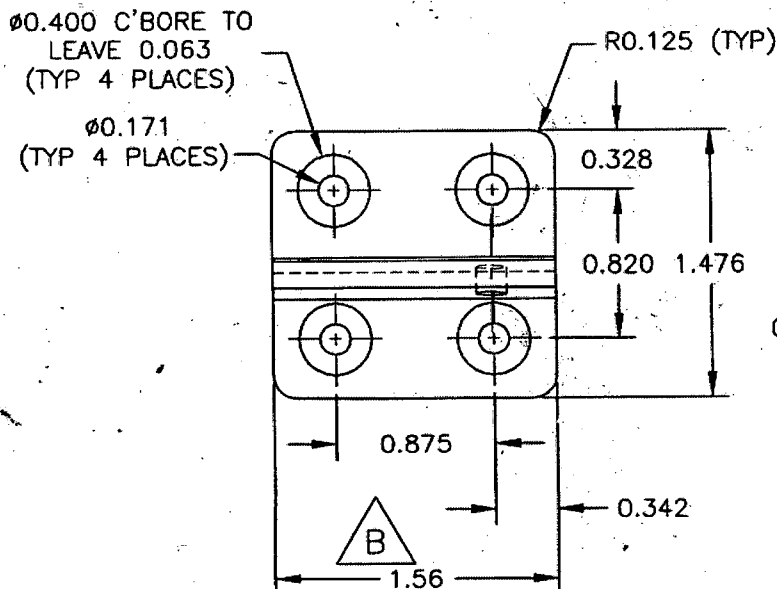
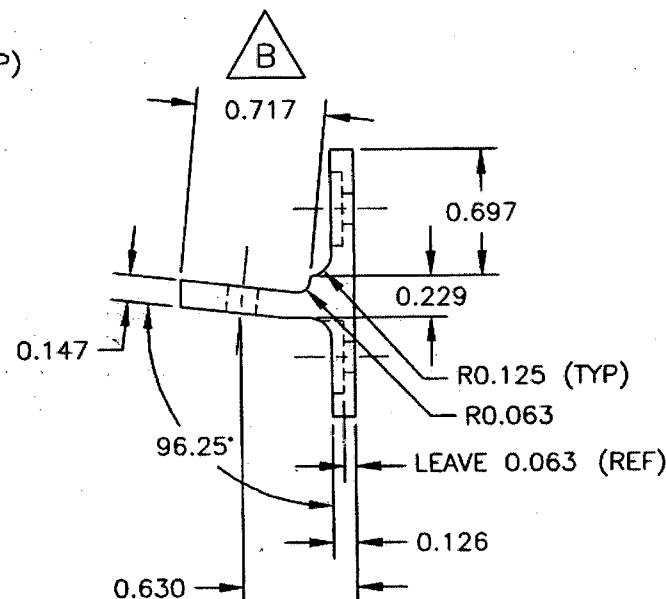
<b>Measured by:</b> H.A. / [Signature]	<b>Audited by:</b> [Signature]	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 08/07/02	<b>Date:</b> 08/07/02	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	07.10.30	New Issue	KJ/EC/DD [Signature]	[Signature]



RELEASED  
99.07.03 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD
KE	KE	HAWKESBURY, ONTARIO, CANADA
CHECKED CP	APPROVED KE	DRAWING NO.
		D2858
DATE 99.02.28	TITLE HINGE BRACKET	SHEET 1 OF 1
		SCALE 1:1
A	98.12.14	NEW ISSUE
B	99.02.28	0.717 WAS 0.667, 1.56 WAS 1.559



ENGRAVE P/N CENTERED ON  
BASE 0.003 DEEP (0.010 MAX)

2858-1 SHOWN  
2858-2 OPPOSITE

MATERIAL: 6061-T6 ALUMINUM (QQ-A-250/11) OR (QQ-A-200/8) OR (QQ-A-225/8)  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

NO. 3787  
WORK ORDER  
WITHOUT NOTICE  
SUBJECT TO AMENDMENT  
UNCONTROLLED COPY  
ENGINEERING  
RETURN TO  
SHOP